



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Rush

D3248-1
Job Sheet 169420



Part No: D3248-1

Job Qty: 12 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/11/17

Job Tracking No:

Due Date: 12/13/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV A IPP B 04.10.26 D3248-1 no longer made in house. IPP Rev:C 11.02.07 now made on W.J. DD
verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	12/12/17	12/12/17	0.00	0.00	Start Up Waterjet		<i>SL</i>
100	Waterjet	12 pcs	12/12/17	12/12/17	0.25	0.60	Waterjet1		<i>SC</i>
110	QC	12 pcs	12/12/17	12/12/17	0.00	0.00	QC2		<i>SC DAS</i>
120	QC	12 pcs	12/12/17	12/12/17	0.00	0.00	QC8		<i>38</i>
130	HandFinish	12 pcs	12/13/17	12/13/17	0.00	0.30	HandFinish1	<i>DAS</i>	<i>BEB 12/12/11</i>
140	QC	12 pcs	12/13/17	12/13/17	0.00	0.00	QC2	<i>7-5 1489</i>	<i>SB</i>
150	Packaging	12 pcs	12/13/17	12/13/17	0.00	0.00	Packaging3		<i>SP</i>
160	QC21-SA	12 Ea	12/13/17	12/13/17	0.00	0.00	QC21		<i>SB</i>

Part Op Descriptions: 100 - 1-Cut as per Dwg Dwg Rev: *A* Prog Rev: *A* 2-Deburr if necessary

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M5052H32S.063	11	68	0	0

5004786

Part Specifications

Specifications could not be found.

Plex 12/11/17 11:52 AM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval _____
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Description Work Order Deviation	Disposition	Completed By _____
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Mfg Date: 12/11/17
Job No: 169420

Start up Operation
D3248-1

Change No: _____
Operation: _____
Revision: _____
PART NO: _____

Hand / Supervisor
Approval Verification

QA Coordinator
Approval

Root Cause		
Environment ☐	No Re-verification ☐	Pressure/F ☐
Design ☐	Operator ☐	Bending ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/ ☐
Material ☐	Use for Testing ☐	Cuffs ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐
LOA ☐	Product Improvement ☐	Wave/Twist in ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐
Past Expiry Date ☐	Manufacturing Process ☐	
Misidentified ☐	Past Due ☐	OTHER : _____

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Instructions Incomplete/Unclear

Drill Holes



Mislabeled ☐
Fit/Function ☐
Misaligned/off center ☐

Drawing ☐
Finish ☐
Misread ☐
Turning Sequence ☐

Used Wrong ☐
e Dimensions ☐
Under tolerance ☐
Correct ☐
t/Missing ☐
ved ☐

